



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3208-7
Job Sheet 179694



Part No: D3208-7

Job Qty: 6 ea

Part Name: Filler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEET 7 IPP: B 04.05.25 Material changed for Step 4 KJ/JLM IPP REV C:PER REV B 12-03-23
JLM VERIFIED BY:EC IPP REV:D 12.04.20 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		SC 18/07/18
100	Waterjet	6 pcs	7/18/18	7/18/18	0.01	0.15	Waterjet1		SL 18/07/18
120	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC8		38
130	HandFinish	6 pcs	7/18/18	7/18/18	0.00	0.16	HandFinish1		SA 18-07-05
140	QC	6 pcs	7/18/18	7/18/18	0.00	0.00	QC7-2		38
150	Packaging	6 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3	START JUL 24 2018	38
160	QC21-SA	6 Ea	7/18/18	7/18/18	0.00	0.00	QC21		38
Part Op 100 - 1-Cut as per Dwg									DAS 21 9-86 JUL 24 2018
Descriptions:									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	.5412 sf (.0902 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	1	78	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Filler	0.098inches + 0.005 - 0.001	0.103 0.097	0,100	
2	Filler	2.900inches ± 0.030	2.930 2.870	2,897	
3	Filler	3.950inches ± 0.030	3.980 3.920	3,948	
4	Filler	0.130inches ± 0.030	0.160 0.100	0,129	
5	Filler	0.080inches ± 0.010	0.090 0.070	0,080	

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Suspected Unapproved ☐ Rework ☐ Use-as-is ☐ Scrap ☐ Suspected Unapproved ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Thermoforming ☐ Large Fab ☐ Rec/Store/Packaging ☐ Finishing ☐ Composite ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐																																				
Date : _____ Step #: _____		MRB (QSI042) Approval _____																																					
Description Work Order Deviation																																							
DART AEROSPACE Container No: S088895 Part: D3208-7 Job No: 179694 Serial No/Batch: S088895 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/03/18																																							
Completed By _____ ad hand / Supervisor _____ approval Verification _____ QA Coordinator _____ Approval _____																																							
Root Cause <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td>Environment</td> <td>No Re-verification</td> <td>Pressure/</td> </tr> <tr> <td>Design</td> <td>Operator</td> <td>Bending</td> </tr> <tr> <td>Doc/Data</td> <td>Offset/Setup</td> <td>Centre No</td> </tr> <tr> <td>Equip/Tooling</td> <td>Supplier</td> <td>Cracks</td> </tr> <tr> <td>Handling/Pre</td> <td>Training</td> <td>Crimp/Kink</td> </tr> <tr> <td>Material</td> <td>Use for Testing</td> <td>Cuffs</td> </tr> <tr> <td>Internal Transport</td> <td>Poor Information</td> <td>Crushing</td> </tr> <tr> <td>Tribal Knowledge</td> <td>Rushing</td> <td>Heat Treat</td> </tr> <tr> <td>LOA</td> <td>Product Improvement</td> <td>Wave/Twist in Tube</td> </tr> <tr> <td>Substation</td> <td>Process Improvement</td> <td>Marks/Chatter</td> </tr> <tr> <td>Past Expiry Date</td> <td>Manufacturing Process</td> <td></td> </tr> <tr> <td>Misidentified</td> <td>Past Due</td> <td></td> </tr> </table>				Environment	No Re-verification	Pressure/	Design	Operator	Bending	Doc/Data	Offset/Setup	Centre No	Equip/Tooling	Supplier	Cracks	Handling/Pre	Training	Crimp/Kink	Material	Use for Testing	Cuffs	Internal Transport	Poor Information	Crushing	Tribal Knowledge	Rushing	Heat Treat	LOA	Product Improvement	Wave/Twist in Tube	Substation	Process Improvement	Marks/Chatter	Past Expiry Date	Manufacturing Process		Misidentified	Past Due	
Environment	No Re-verification	Pressure/																																					
Design	Operator	Bending																																					
Doc/Data	Offset/Setup	Centre No																																					
Equip/Tooling	Supplier	Cracks																																					
Handling/Pre	Training	Crimp/Kink																																					
Material	Use for Testing	Cuffs																																					
Internal Transport	Poor Information	Crushing																																					
Tribal Knowledge	Rushing	Heat Treat																																					
LOA	Product Improvement	Wave/Twist in Tube																																					
Substation	Process Improvement	Marks/Chatter																																					
Past Expiry Date	Manufacturing Process																																						
Misidentified	Past Due																																						
OTHER : _____																																							
Wrong Stock Pulled Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐																																							
Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐																																							
ioned Wrong ☐ de Dimensions ☐ Under tolerance ☐																																							
Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																																							